

Work Order ID 54645

December 15, 2009 12:04:31 PM

Page 1

Item ID: D3508-13

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 12/15/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-12-15

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

MAT NOT PULLED

B 10-1-11

304 .040

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

R 10-1-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8/10/11

116

Pro ->

W/O: 54645		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/11	#120	Took Qty +1 Part For QC inspection Template	S	10/1/11	✓	N	S 10/1/11

Part No: D3508-13 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54645

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Item ID: D3508-13

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Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/15/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 12.00



Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form on brake using DT8326 and DT8261 as per Dwg D3508

0.00

0.00

80 10/01/19

16 8

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

80 10/01/19

16 4

150



Large Fab

Large Fab

Large Fab

Memo

Weld hardcoat as per dwg D3508 QSI004 Hardcoat 2059b Batch: M113521

0.00

0.00

EL 10-1-20 15

PRC ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3508-13 PAR #: N/A Fault Category: Large Feb NCR: (Yes) No DQA: 18 Date: 10.01.21
 Resolution: Acceptable Disposition: Use-as-is QA: N/C Closed 7/2 Date: 10/01/26

NCR: <u>54645</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/20	# 150	welder welded the two strings of "hard coat" wrong. He welded the 1.63" gap at the wrong end R.C. LPA. He wasn't paying	<u>18</u> <u>09/12</u>	-Part is acceptable. no structural etc only a wear plate	<u>EZ</u> <u>10-1-20</u>	<u>S</u> <u>10/1/20</u>	<u>18</u> <u>09/12</u>	<u>S</u> <u>10/1/20</u>
		full attention to the Layout only the Dim's on the Dwg.						<u>S</u> <u>10/1/20</u>

NOTE: Date & initial all entries

Work Order ID 54645

December 15, 2009 12:04:31 PM

Page 3

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Revision ID:

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Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

=> 8.06.12.00

(x16)

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

=> 8.06.12.00

(x16)

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

=> 8.06.12.00

(x16)

Powdercoat

Memo

0.00

Powder Coating

START TIME: 6:45AM OVEN TEMPERATURE:
7:15AM FINISH TIME: 370°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 54645

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Item Name: Wearplate

Start Date: 12/15/2009 Start Qty: 12.00

Required Date: 12/22/2009 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

BK 10-01-21

(16)

Ø

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location:

FP-17

0.00

=> MF 10-01-21

(X16)

Ø

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

10/01/21 J

QC

Memo

0.00

Quality Control

MF 10-1-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54645



Parent Item: D3508-13

Parent Item Name: Wearplate

Start Date: 12/15/2009

Required Date: 12/22/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	306.3536	2.1726	3.1		



304/316 .040 Sheet

B 10-1-11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

306.3536158

110076

1.37053684

112567

38.0765789

112885

83.1578

113062

166.3723

113077

17.3764

112885

17

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 54645
Description: Wearplate		Part Number: D3508-13
Inspection Dwg: D3508	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.38	+/-0.030	8.382	✓			
5.625	+/-0.010	5.624	✓			
0.375	+/-0.010	.377	✓			
2.813	+/-0.010	2.807	✓			
2.063	+/-0.010	2.069	✓			
Ø0.187	+0.005/-0.001	.191	✓			
0.300	+/-0.010	.303	✓			
0.300	+/-0.010	.304	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-1-11	Date: 10/01/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.23	New Issue	KJ/EC/DD	JD

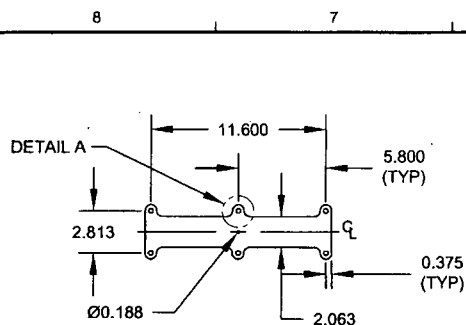
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

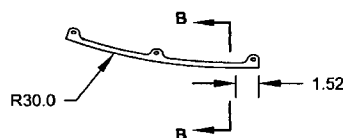
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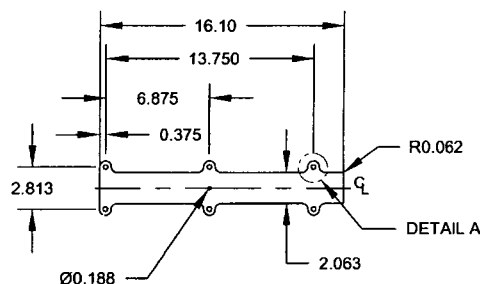
NOTE: Date & initial all entries



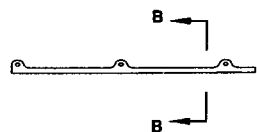
D3508-1 FLAT PATTERN



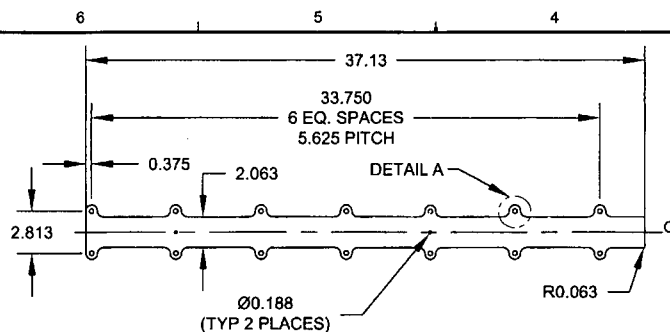
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



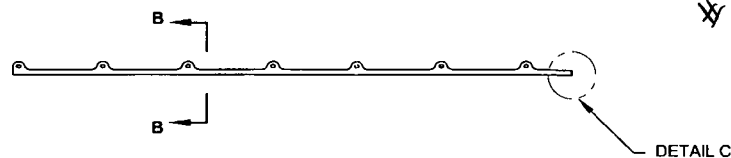
D3508-7F FLAT PATTERN



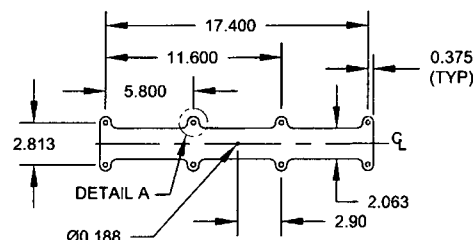
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



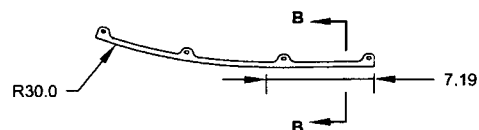
D3508-3 FLAT PATTERN



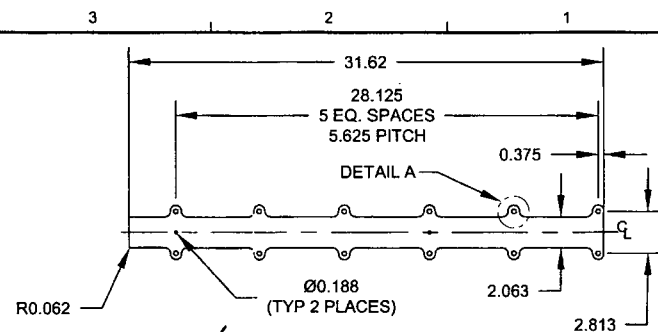
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



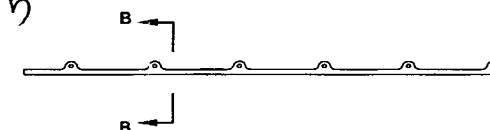
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE

DESIGN	<i>244</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>244</i>		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>140</i>	D3508	SHEET 1 OF 2
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

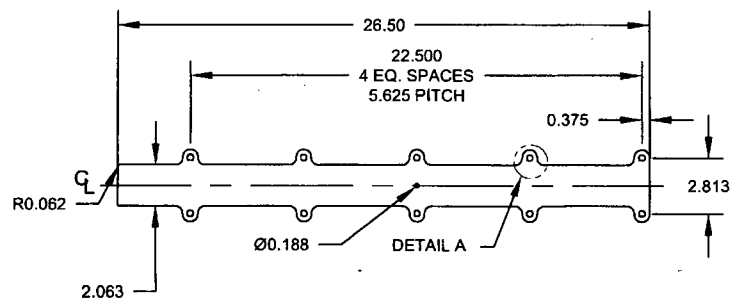
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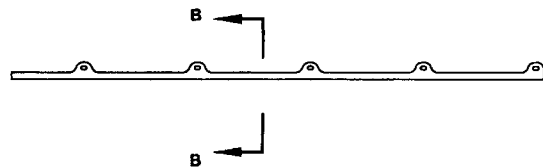
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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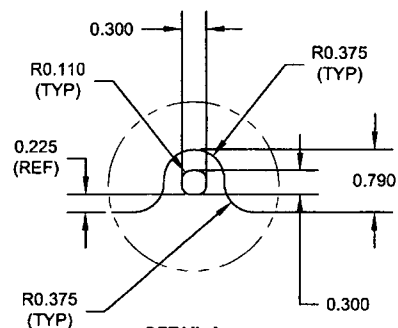
NOTE: Date & initial all entries



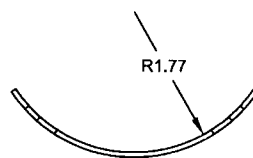
D3508-11F FLAT PATTERN



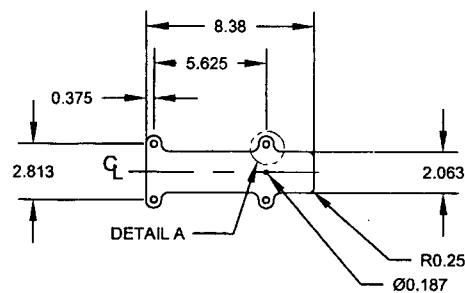
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



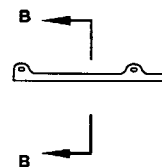
DETAIL A
(SCALE 2:3)



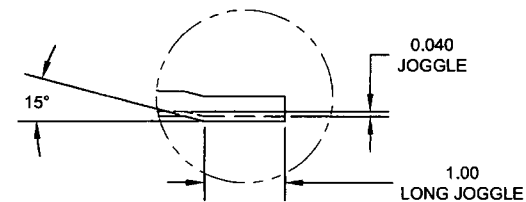
SECTION B-B
(SCALE 2:3)



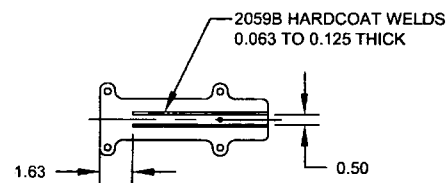
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

#54645

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:1
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